



PRESENTATION

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OBJECTIVES

After completing Module 20, a trainee will be able to accomplish the following without the aid of references.

1. Describe the proper location for conducting SIS presentation monitoring tests.
2. State the frequency of SIS presentation monitoring tests when the presentation process is in control.
3. State the interval between presentation retests.
4. State when evisceration line speed is checked during presentation tests.
5. State how many inspection stations must be monitored for presentation.
6. List the three parts of a presentation monitoring test.
7. Shown a slide or picture, identify presentation errors and describe the correct inspection action.
8. List three categories of carcasses that must be hung back by the inspector's helper.
9. State the circumstances that require the IIC to establish appropriate line speed.
11. State how long IIC-established line speed is maintained.

INTRODUCTION

During the development of the Streamlined Inspection System, time and motion studies were done for presentation at inspection stations to determine the effect of presentation errors on the inspector. Each type of presentation error was assigned a weight based upon the severity of that effect.

The importance of good, consistent postmortem presentation cannot be over stressed. Industry is responsible for process control, and consistently correct presentation is critical to process control.

PRESENTATION TEST

FSIS developed a test that demonstrates that measures presentation process control. Carcasses are observed for presentation errors, a weight is applied to each error, and the total of the weighted errors is calculated. Line speeds may remain the same, be reduced, or be increased based on this weighted total.

Each inspection station on each line is monitored individually for presentation effectiveness and the results of the tests are recorded on FSIS Form 6510-1.

The recommended frequency for Inspection's presentation monitoring tests is twice per shift; however, the minimum frequency is once per shift.

PRESENTATION MONITORING TEST PROCEDURE

Three parts of a presentation monitoring test are:

- **outside errors observation**
- **inside errors observation**
- **line speed check**

Outside, inside, and line speed errors are converted to weighted scores and totaled to determine whether presentation is acceptable at each inspection station.

1. OUTSIDE ERRORS

At a point offline, *behind and between the presenter and the inspector*, observations are made on 10 carcasses for *outside* errors, then are recorded on FSIS Form 6510-1.

Description of Outside Carcass Errors

A. Front or side

Birds arriving with other than the back of the bird toward the inspector.

B. Not hung by two legs

Birds arriving with both legs not properly suspended in the shackle.

C. Birds swinging

Birds arriving with sufficient swinging motion to interfere with the inspection process.

D. Viscera not uniform

Birds arriving with viscera on the opposite side of normal presentation, in the middle of the abdominal opening; or with the membrane attached to the abdominal opening and tail, which interferes with the viscera observation.

E. Contaminated viscera

Birds arriving with contaminated viscera, which may affect postmortem inspection effectiveness or efficiency.

F. Viscera below wing

Birds arriving with the visceral organs below the wing breast joint.

G. Viscera not free

Birds arriving with viscera not free of fat and suspended along side the carcass.

H. Viscera in shackle

Birds arriving with visceral organs hung in the shackle.

I. Out of sequence

Birds arriving on guide bar out of sequence for the inspection station due to kick out malfunction.

J. No viscera

Birds arriving without viscera.

2. **INSIDE ERRORS**

Stepping up to an online position, at a point *between the presenter and inspector*, another 10 carcasses are observed for *inside* errors. Then the inside errors are recorded on FSIS Form 6510-1.

Description of Inside Carcass Errors

A. Membrane

Birds arriving with inside cavity obstructed by air sac membranes from viscera to cavity.

B. Opening cut

Birds arriving with inside cavity obstructed by inadequate opening cut. Opening cut should be sufficient to allow adequate inspection of the inside of the carcass.

C. Not reflected

Birds arriving with the viscera not reflecting the appropriate abdominal flap.

D. Parts inside

Birds arriving with one or more of the visceral organs left in the cavity.

E. Contamination inside

Birds arriving with contamination occurring on the inside surfaces of the carcass.

F. **Mutilation**

Birds arriving mutilated by the vent or evisceration equipment, which may affect inspection efficiency.

3. **LINE SPEED ERRORS**

After presentation has been tested at every inspection station on an eviscerating line, the speed of that line is counted. Each bird per minute exceeding the current maximum for that line equals one error.

HANG BACK BIRDS

Whenever an inspector cannot perform postmortem inspection because a presentation error interferes with proper observation of the carcass, the bird should be hung back for correction of the error. After correction the carcass can be re-presented for postmortem inspection.

Three types of carcasses are impossible to inspect. The inspector should automatically instruct the helper to hang back these birds for re-presentation when they arrive at the inspection station. They are not counted as one of the 10 sample birds during a presentation test. These carcasses are:

- **not opened**

Bird arrives at inspection station with no opening cut made in the carcass.

- **not drawn**

Bird arrives at inspection station with opening cut made but with viscera drawn insufficiently to permit inspection.

- **with two legs out of the shackles**

Bird arrives at inspection station hung by head or wing.

Birds hung back for re-presentation must be handled in a sanitary manner and placed back into the flow of product quickly so that product wholesomeness is not compromised.

LINE SPEED ACTION

A line presentation test is in *questionable* control if the test reveals:

- ≥ 3 occurrences of one error
- a score ≥ 25 through 39

The IIC will retest every inspection station on a line within 10 minutes of a presentation test found to be in questionable control.

A line presentation test is *not in control* if the test reveals:

- a score of ≥ 40
- a retest with ≥ 3 occurrences of one error or a score ≥ 25

The IIC will instruct the plant to reduce line speed 10% when presentation process control is not demonstrated.

If *three consecutive line speed reductions* do not result in process control, the IIC will evaluate the presentation problem. He/she will determine an acceptable line speed. That speed will remain in effect until the problem lot of birds is completed or the problem is corrected.

Whenever retests of all inspection stations on a line running at reduced speed indicates that presentation process control has been reestablished, line speed may be increased 10% of its current rate. (Line speed increases at the same rates it was decreased.) Process control must be demonstrated at each speed before additional line speed increases are allowed. This procedure continues until maximum allowed speeds are attained.

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MARCH 2000

Sample Form FSIS 6510-1

WORKSHOP

In each of the following situations, select the best postmortem inspector action from the choices below.

- a. Hang the bird back for re-presentation.
 - b. Inspect the bird; make a disposition.
 - c. Notify the SVMO.
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- _____ 1. A bird is presented hung by the neck.
 - _____ 2. A bird is presented with part of a membrane. You can see down into the thoracic inlet.
 - _____ 3. A bird is presented with one leg out of the shackle. You can see down into the thoracic inlet.
 - _____ 4. A bird is presented with the viscera not drawn.
 - _____ 5. A bird is presented with contamination inside. Out of the last 20 birds, this is the sixth bird in which you have observed contamination inside the body cavity.
 - _____ 6. Your bird is out of sequence. You see it going passed behind the guide bar.
 - _____ 7. A bird is presented with the liver lying in the abdominal cavity. You can see down to the thoracic inlet.
 - _____ 8. A bird is presented with the liver and heart in the abdominal cavity. You cannot see down to the thoracic inlet.
 - _____ 9. A bird is presented which has not been opened.
 - _____ 10. A bird is presented with the fat still attached to the viscera. You cannot see the whole liver, or the heart or spleen because of the fat attachment.
 - _____ 11. A bird is presented which has been badly mutilated by the eviscerator.
 - _____ 12. When a bird whose flap had been reflected reaches your station the viscera has slipped and the flap has rolled back into the abdominal opening. You can see

down to the thoracic inlet.

- _____ 13. A bird whose flap had been reflected reaches your station with the flap rolled back into the abdominal opening because the viscera slipped. Of the last ten birds presented, this is the fourth bird presented this way.
- _____ 14. A bird is presented with a ½" opening cut. You noticed that Jane, the "old-timer" inspector across the line from you, tore the opening to inspect a similar bird.
- _____ 15. A properly drawn bird is presented with its side facing you.

Using your script answer the following questions.

- 1. What are the three parts of a presentation monitoring test?
- 2. Where are observations for outside errors made during a presentation monitoring test?
- 3. Where are the observations for inside errors made during a presentation monitoring test?
- 4. When is line speed checked during a presentation monitoring test?
- 5. Name two reasons related to presentation that an inspector should hang back a bird.

Using FSIS Form 6510-1, list the outside errors.

- 1.
- 2.
- 3.
- 4.
- 5.
- 6.
- 7.
- 8.
- 9.
- 10.

Using FSIS Form 6510-1, list the inside errors.

- 1.
- 2.
- 3.
- 4.
- 5.
- 6.

List the third type of SIS presentation error.

- 1.

List the three reasons to hang back birds.

- 1.
- 2.
- 3.

Good luck finding your answers in the following word seek puzzle!

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M E V A V I S C E R A O N S H A C K L E Q C W W E
B E I U R K M R O F I N U T O N A R E C S I V E B
V R S E R Y U Q N T F M W I L E F D S C E T D K G
D F C A V V F N O T R E F L E C T E D E K R F T Y
S T E A R M W N N W A R D T O N Y M L B I W E V V
F O R N O E T N M W O R V K J E Z Z F B N J D E E
A N A E U M C I O U S V X S T U Z G E L O H I E L
N A B R T B S S A I Y N X Y K Q A D E K L E S M K
A R E E R R I O I B T U T H R E I J X V Z E R O C
N E L V R A L Q U V E A V J R S T O V D H F O D A
B C O J M N E A J X N L L K N F P O M E H G T T H
I S W U Y E A S W B Q O V I S O C T Y E N T N F S
R I W E E G W R E A X B N E T T A K L P U T O R F
N V I H X I N N M Y T O O O T U J F D S K P R M O
R Y N I N E G F K V I Q T Z I O M F H E E M F U T
U H G G R A Y O K T U R O W R T L V R N E P E V U
B G I R F E S D A F V F P J L M A X I I I O M R O
H N E V W W E N R K L A E R B T E N A L H J D I S
G A N I N R I N E L E V N D R B G T I X R W I L G
B G J C E M A U C Q S Q E M K C K I R M N V X E E
Z C P W A B M L S O O R D B U V H E K I A M W R L
P A R T S I N S I D E D E T O X R E T T C T V K O
G Q N N J I L I V X A R Y A F H L O P E V E N W W
R O N H E J L N O T H U N G B Y T W O L E G S O T
C E B I L G R A N A Z F H B A E R L W J O I B E C